

Work Order ID 78389

78389

Page 1

January-09-12 8:52:53 AM

Item ID: D206-642-213

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 09/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/01/09

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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IIN-D206-642	0
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP206-642-213 CHG006

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

1376976

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

* Work Order ID 78389

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Item ID: D206-642-213

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH

Stop *NS2*

Start Date: 09/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-213 Location: <u>82</u> Rev F								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1x Sp 12-04-10

12/4/12

12-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 78389

78389

Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.07.14ECN 847 & 901; Add Tow Ring and GHW
KitKJ/CP/JLM
IPP Rev:L 07-12-04 ECN 1080p DD verified by: IPP rev M
10.02.02 per IIN rev M EC verified by: JLM IPP REV:N 11.11.17
PER IIN REVO DD VERF;EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-44A *AN6-44A* Bolt		Purchased	No			110	Each	337.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>						
				ST343			7						
				119127			7						
				st510			330						
				119036			330						
AN960C416 *AN960C416* washer	NAS1149C0463	Purchased	No			110	Each	0.0000	1	1			
AN960JD10 *AN960.ID10* Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	8	8			
AN960JD416 *AN960.ID416* Washer	NAS1149D0463J	Purchased	No			110	Each	0.0000	24	24			
AN960JD516 *AN960.ID516* Washer	NAS1149D0563J	Purchased	No			110	Each	0.0000	8	8			
AN960JD616 *AN960.ID616* Washer	NAS1149D0663J	Purchased	No			110	Each	0.0000	4	4			

**

**

**

**

**

**

M117738

M120644

M121255

M119712

M120644

12/4/5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 78389

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Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D206-642-241

Manufactured No

110

Each

0.0000

D206-642-241

Replacement Skidtube

D206-651-041

Manufactured No

110

Each

0.0000

D206-651-041

206A/B GHW

D2652

Manufactured No

110

Each

991.0000

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

947

73834

15

73836

36

76132

96

76133

400

77135

400

D2665-1

Manufactured No

110

Each

12.0000

D2665-1

Saddle; LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

ST436

12

52306

8

55017

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 78389

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Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2666-1

Manufactured No

110

Each

18.0000

D2666-1

Saddle, LH Fwd Aft In 206

**

Location

Loc Qty

Loc Code

ST426

18

52847

4

55018

6

60296

4

60870

4

D2667-1

Manufactured No

110

Each

5.0000

D2667-1

Saddle, LH Aft Out 206

**

Location

Loc Qty

Loc Code

ST427

5

42409

5

D2668-1

Manufactured No

110

Each

6.0000

D2668-1

Saddle, LH Aft In 206

**

Location

Loc Qty

Loc Code

ST427

6

40898

2

52348

4

D2712

Manufactured No

110

Each

1,642.000

D2712

Set Screw

**

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1592

76065

1592

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 78389

78389

Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2884

Manufactured No

110 Each

367.0000

2 2

**

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

357

76751

357

Manufactured No

110 Each

358.0000

2

**

D2885

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

348

76752

348

Manufactured No

110 Each

59.0000

1 1

**

D3413-1

D3413-1

Ring

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

55

73822

3

75478

52

ST473

2

71041

2

B80224 12/4/5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 78389

78389

Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

6,189.000

8 8

**

M121162

MS21042I 3

Nut

Location

Loc Qty

Loc Code

ST300

6189

117441

16

117885

32

118451

5

118927

3

119017

5610

119075

523

MS21042L4

Purchased

No

110

Each

8,007.000

12 12

**

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

8007

117441

51

117601

342

118451

133

119017

2481

119075

5000

MS21042L5

Purchased

No

110

Each

2,050.000

2 2

**

MS21042I 5

Nut

Location

Loc Qty

Loc Code

ST300

2050

116105

5

116548

43

117611

50

118179

452

119109

1500

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 78389

78389

Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

110

Each

1,146.000

Start Qty: 1.00

**

MS21042L6

Nut

Location

Loc Qty

Loc Code

ST300

1146

117677

25

118384

5

118927

48

118968

18

119075

1000

119736

50

AN3-41A

Purchased

No

120

Each

959.0000

**

AN3-41A

Bolt

Location

Loc Qty

Loc Code

ST354

959

119042

959

AN4-6A

Purchased

No

120

Each

3,572.000

**

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

3572

119017

3572

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78389

Parent Item: D206-642-213

Parent Item Name: Skidtube LH

78389

D206-642-213

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

120

Each

399.0000

1 1

AN4C5A
BOLT

**

Location

Loc Qty

Loc Code

FP002

19

112243

19

ST355

380

112243

280

119017

100

Purchased

No

120

Each

1,251.000

4 4

AN5-11A

AN5-11A
Bolt

**

Location

Loc Qty

Loc Code

ST337

1251

118191

13

119512

1238

Purchased

No

120

Each

215.0000

2 2

AN5-32A

AN5-32A
Bolt

**

Location

Loc Qty

Loc Code

ST339

215

118422

2

118628

38

118983

25

119328

100

119862

50

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 78389

78389

Parent Item: D206-642-213

D206-642-213

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-7A

Purchased

No

120

Each

2,821.000

4 4

AN5-7A

Bolt

**

12/4/15 J

Location

Loc Qty

Loc Code

ST337

2821

117313

6

118422

1

119017

2814

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.3 206A/B HIGH GEAR SKIDTUBES

ITEM	QTY -211	QTY -212	QTY -213	QTY -214	QTY -241	QTY -247	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
1	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-247	WEARSHOE KIT (REPLACES -243)
1	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽³⁾
1					1		D2650-3	SKIDTUBE ASSEMBLY
2A					18		D2651-1	* PLUG ⁽¹⁾
2B					18		D2651-3	* O-RING ⁽¹⁾
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		MS27039-1-08	* SCREW ⁽¹⁾
5					2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3-41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4			AN5-7A	BOLT
14	4	4	4	4			AN5-11A	BOLT
14A			2	2			AN5-32A	BOLT ⁽²⁾
14B			2	2			MS21042-5	* NUT (OR MS21042L5) ⁽²⁾
15	8	8	8	8			NAS1149D0563J	* WASHER (OR AN960JD516)
16	12	12	12	12			AN4-6A	BOLT
17	24	24	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12			MS21042-4	NUT (OR MS21042L4)
20A					4	4	D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1	D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)
22B					1	1	D3536-13	GASKET
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)
23B					1	1	D3536-21	GASKET
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)
24B					1	1	D3536-33	GASKET
26A					44	44	MS27039C1-08	SCREW
26B					44	44	NAS1149C0332R	WASHER (OR AN960C10L)
26C					44		ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6-44A	BOLT
29A	2	2	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1	1	1			AN4C5A	BOLT
35	1	1	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1			D3413-1	RING (REPLACES D2655)
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-3 ASSEMBLY ABOVE

(2) MAY BE REQUIRED ON -213/-214 INSTALLATIONS

(3) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

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Revision: 0

Date: 11.06.15